

Date: Thursday, 2/1/2007 2:49:51 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HEATER EXTERIOR SHEET
Job Number	: 30579		
Estimate Number	: 12691		
P.O. Number	: <i>N/A</i>	Part Number	: D2295
This Issue	: 2/1/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2295 REV B
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	:	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	: <i>N/A</i>
Written By	:	Due Date	: 3/15/2007
Checked & Approved By	:	Qty:	4 Um: Each
Comment	: Est Rev:A New Issue 07-02-01 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S032	6061-T6 Sheet 0.032"
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Comment: Qty.: 2.6250 sf(s)/Unit Total : 10.5000 sf(s)

6061-T6 Sheet 0.032"

Batch: *M18375*

*FF 07-03-06*

*4*

2.0	<del>WATER JET</del> <i>SMALL FAB.</i>	FLOW WATER JET
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Comment: ~~FLOW WATER JET~~  
*SMALL FAB.* as per Dwg D2295

Dwg Rev. \_\_\_\_\_

Prog Rev. \_\_\_\_\_

*2-DRILL AS PER Template T2295 DS.*

*3-Deburr if necessary*

*FF 07-03-08*

*4*

3.0	<del>QCS</del>	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*07/03/12 (4)*

4.0	<del>QCS</del>	SECOND CHECK
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Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*04/03/13 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PP Date: 07/03/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/1/2007 2:49:51 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEATER EXTERIOR SHEET

Job Number: 30579

Part Number: D2295

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

Doc 07/03/14

Job Completion



u 07-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

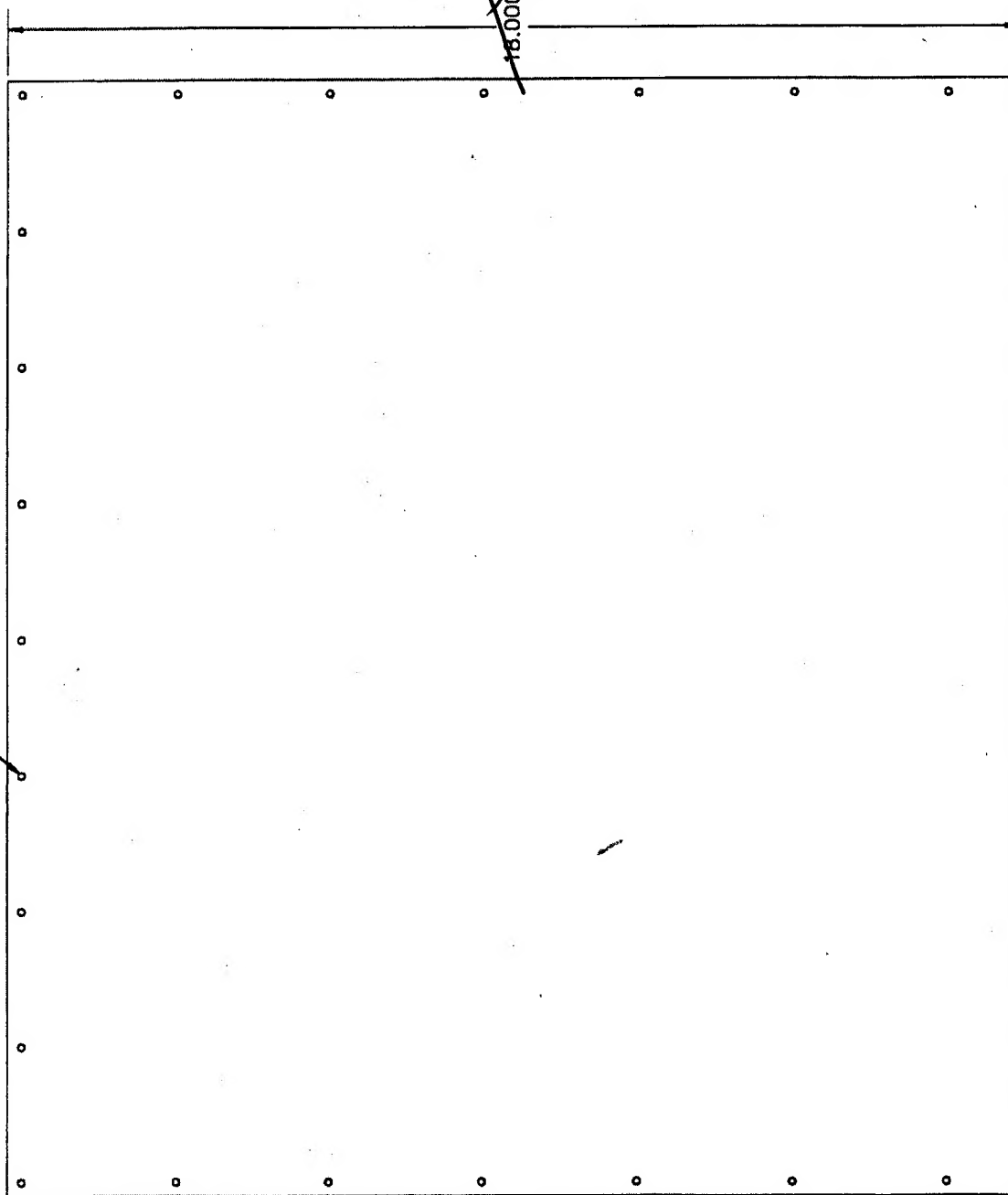
**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2295	SHEET 1 OF 1
DATE	TITLE		SCALE
94.10.25	HEATER EXTERIOR SHEET		1:3
B	96.01.15	DEFINE HOLES	

*20.000*  
*18.000*  
*07.03.12*

Ø0.128 DRILL PER TEMPLATE T2295DJ



*07.03.12*  
*18.000*  
MATERIAL: 6061-T6 OR 5052-H34 SHEET  
0.032 THICK CUT 18 X 20

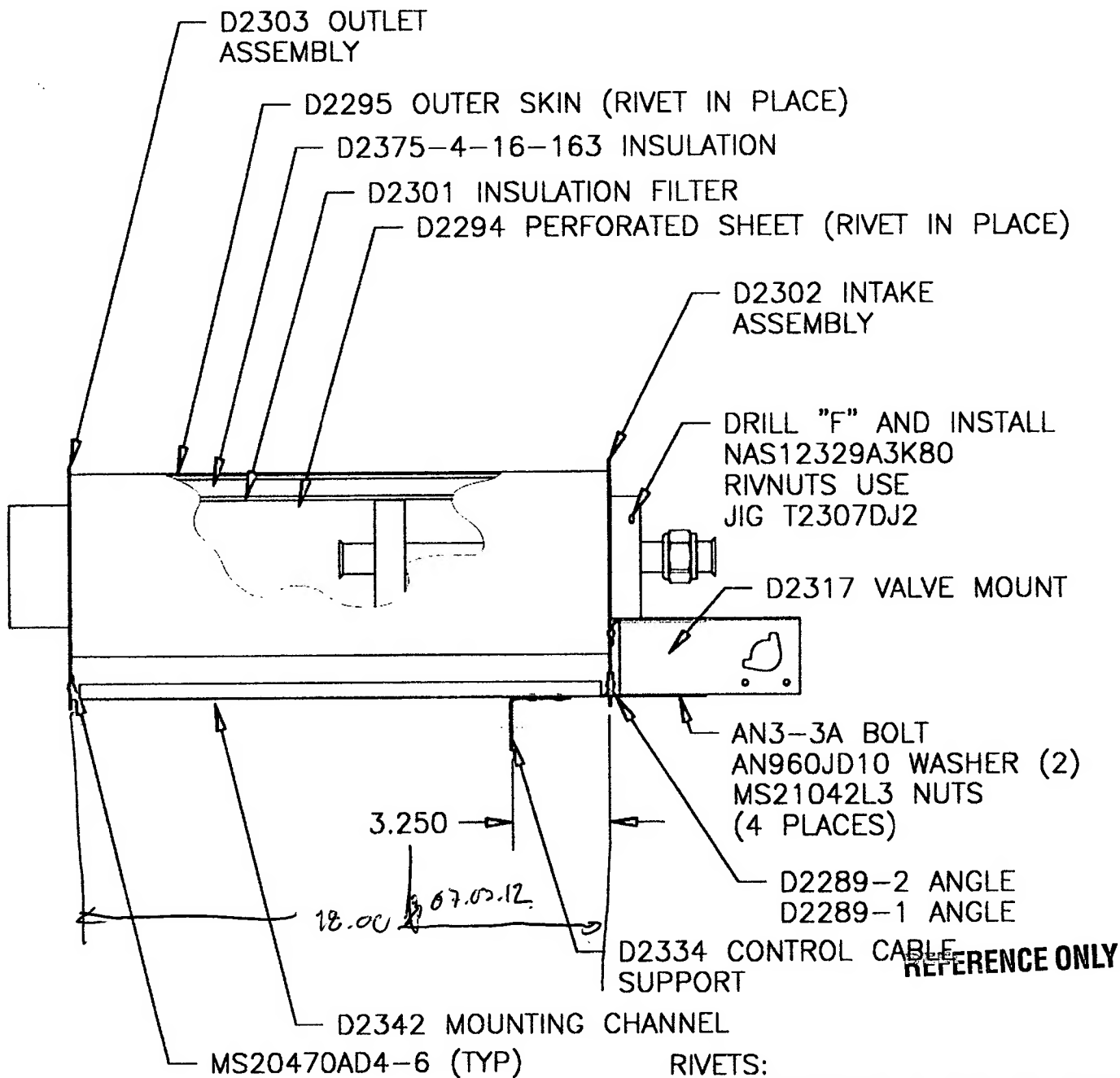
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *30579*



DESIGN <b>B WILLIAMS</b>	DRAWN BY <b>B WILLIAMS</b>	<b>DART AEROSPACE LTD</b> VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. <b>D2306</b>	REV. C SHEET 1 OF 2
DATE <b>95.01.03</b>		TITLE <b>B204 ASPIRATOR ASSEMBLY</b>	
<b>B</b>	<b>Apr. 13, 1995</b>	<b>REVISED D2317</b>	
<b>C</b>	<b>96.01.19</b>	<b>ADDED DETAIL</b>	

QTY	Part No.	Description
X	D2306	B204 ASPIRATOR ASSEMBLY
1	D2302	INTAKE WELDMENT ASSEMBLY
1	D2303	OUTLET WELDMENT ASSEMBLY
1	D2295	HEATER EXTERIOR SHEET
1	D2375-4-16-163	INSULATION
1	D2301	INSULATION FILTER
1	D2294	HEATER PERFORATED SHEET
1	D2289-1	VALVE MOUNTING BRACKET
1	D2289-2	VALVE MOUNTING BRACKET
1	D2317	VALVE MOUNTING BRACKET
1	D2334	CONTROL CABLE SUPPORT
1	D2342	MOUNTING CHANNEL
4	AN3-3A	BOLT
8	AN960JD10	WASHER
7	MS20600AD4W5	RIVETS CR9163-4-2
23	MS20600AD4W6	RIVETS CR9163-4-4
6	MS20470AD4-6	RIVETS
4	MS21042L3	NUTS
2	NAS1329A3K80	RIVNUTS

REFERENCE ONLY

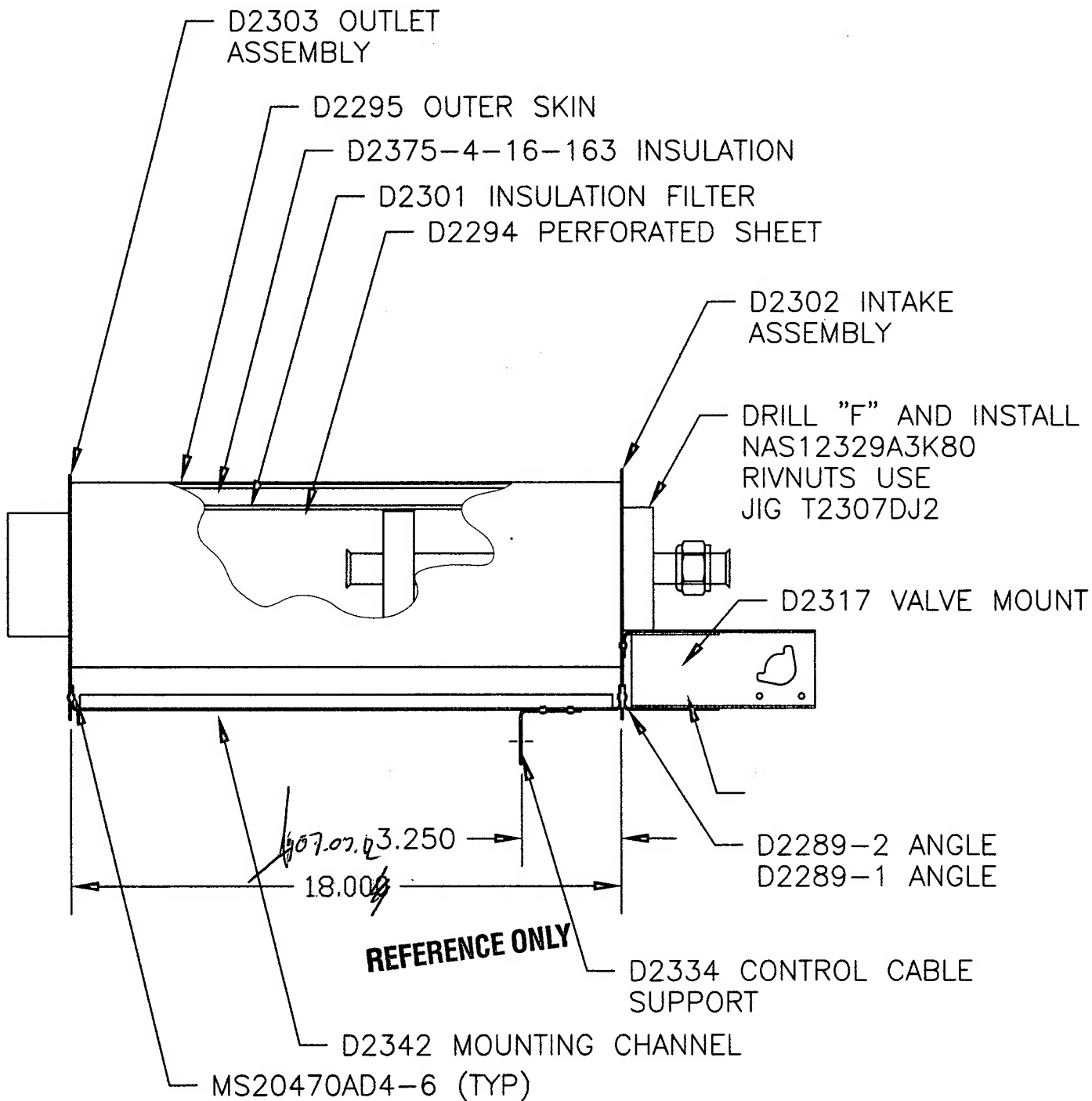


RIVETS:  
MS20600AD4W5 SHEET TO SHEET  
MS20600AD4W6 SHEET TO END

**DART**



DESIGN	B WILLIAMS	DRAWN BY	B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	BW	APPROVED	BW	REV. C
DATE	95.01.03	TITLE	B204 ASPIRATOR ASSEMBLY	SHEET 2 OF 2
				SCALE



DESIGN	B WILLIAMS	DRAWN BY	B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	B WILLIAMS	APPROVED		DRAWING NO. D2306
DATE	95.01.03	TITLE	B204 ASPIRATOR ASSEMBLY	REV. C SHEET 2 OF 2 SCALE
	B	Apr. 13, 1995	REVISED D2317	
	C	96.01.19	ADDED DETAIL	